

WHAT IS CLAIMED IS:

- 2 *Sub*
3 *a2*
1. A method of milling a material comprising:
providing a silicon nitride based cutting tool insert;
cutting at a cutting speed of 1000-3000 m/min; and
feeding at a feeding rate of 0.05-0.5 mm/tooth ^{A-B} to a cutting depth of
0.2-2 mm, *feeding rate* *am clear* *w/ cast iron means*
wherein the material comprises aluminum and cast iron. *exactly*
per spec. p. 12-13, not 1 matl - -
is al. w/ cast iron liners
- 1 2. The method of claim 1, wherein the cutting tool insert has a chip
2 thickness of 0.09-0.17 mm. *hmm*

add a3